

Work Order ID 130629

130629

Page 1

Wednesday, March 18, 2015 8:46:09 AM

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 3/18/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/18/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 15-03-18 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2750-042	G
D3492	C

DAS
27
9-29

100 Document Control 0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

DAS
05
9-29

Doc.Control -USB or Paperwork

record fwd angle: 89.1°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

MAY 07 2015

MLS MAY 05 2015
15-3-19 MAY 05 2015
[Signature]

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1

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.

6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108. open to 0.297".

7- Open up holes of Detail J to 0.297" (total of 2 holes per side)

8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

15-3-19

DGC 15-3-19.

PTO

BB1503-20

DQA:

Date:

15/05/15



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

15/05/12

Work Order update only ☐

Work Order: <u>130629</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D350-636-012</u>		Skid-tube ☒	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4942</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				Rear Blade fitting		Ream hole			
Doc/Data				Bolt Hole To		to $\phi 0.527$			
Equip/Tooling				Tight					
Handling/Pre	15-3-19	110	1		UP		15-3-23		DAS
Material					15/9/23			15-3-23	9-89
Operator									15-3-23
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☒ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

A/R Aluminum Rod batch: M127865 7 BE16-03-020
9- Grind welds flush as per Dwg D2750

120 QC10- Inspect visual per QSI004- ground welds 0.00

120

QC Memo 0.00

Quality Control

① 1503-23

DAS
9
9-89

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC Memo 0.00

Quality Control

DAS
03
9-89

DP 15-3-23

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140	Chemical Conversion Coat per QS1005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

140

HandFinish

Memo

0.00

Hand Finishing

15-3-23 

150	QC7-Inspect Chemical Conversion Coat	0.00							
-----	--------------------------------------	------	--	--	--	--	--	--	--

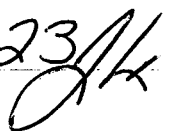
150

QC

Memo

0.00

Quality Control

15-3-23 

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160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750.

3- Open float holes using uni-bit to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube.

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291

batch: 130574exp. date: 15-10-21

ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod

batch: m127865

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

DOL JH 15-3-24

8615-03-27

DP 15-3-30

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Stop ***NR2***

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11- Spot face ground handling holes section (total of 4 places per side) as per
dwg D275012- Deburr holes, ensure tube is free of all scratches before sending to
paint.

170

QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo

0.00

Quality Control

① 150402

DAS
9
9-89

180

QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo

0.00

Quality Control

VERIFY C'BOARD IS GOOD

① 150402

DAS
9
9-89

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 Pressure Wash per QSI005 4.3 0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

15-4-7

200 0.00

200

SprayPaint

Memo

0.00

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2
PRIMER PRC DESOTO 515X349 BATCH: 130992

2- PAINT WHITE AS PER DWG AND QSI 005 4.2
PAINT BATCH: 132624

1 01180312

210 QC14- Inspect Spray Paint 0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

113M d 15104/12

DAS
15
0-89

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

230

HandFinish

Hand Finishing

HandFinishing

Memo

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 1113157J

EXP DATE: 15110

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 11131349 RTU 598 1112579Z exp 15106

5-Coat all exposed fasteners with "LPS Procyon"

batch: 11122900

240

240

QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

DAS

38

9-89

APR 22 2015

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Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MLS MAY 11 2015

Wednesday, March 18, 2015 8:46:15 AM

Page 1

130629

D350-636-012

Required Date: 3/18/2015

Required Qty: 1.00

IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT-RH		Manufactured	No			110	Each	10.0000	1	1			
D2600-3-BENT-RH									**			15-3-18	
Extrusion Bent RH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG002				10					
				130175				10					
D2744		Manufactured	No			110	Each	29.0000	1	1			
D2744									**			15-08-20	
Cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG001				29					
				128212				29					
D2739		Manufactured	No			160	Each	0.0060	1	1			
D2739									**			15-3-23	
350 I Beam													
				130599				①					

Picklist Print

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Start Date: 3/18/2015

Required Date: 3/18/2015

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

81.0000

8

8

D2743

Crossbolt Spacer

**

BE15-03-27

Location

Loc Qty

Loc Code

LG001

81

128943

8

129465

73

D3490-3

Manufactured No

160

Each

41.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE15-03-27

Location

Loc Qty

Loc Code

LG

41

128985

41

D3490-1

Manufactured No

160

Each

1.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE15-03-27
B 130729 *4

Location

Loc Qty

Loc Code

LG001

1

128984

1

D3631-1

Manufactured No

230

Each

162.0000

8

8

D3631-1

Washer

**

15104120

Location

Loc Qty

Loc Code

FP001

162

128320

14

128910

48

129928

100

x8

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Start Date: 3/18/2015

Required Date: 3/18/2015

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No 230 Each 17.0000 1 1

D3791-1

Wearpad

**

all 15104/20

Location	Loc Qty	Loc Code
FP002	17	
125913	1	
126317	16	

D3793-3 Manufactured No 230 Each 12.0000 1 1

D3793-3

Wearplate Aft

**

all 15104/20

Location	Loc Qty	Loc Code
FP002	12	
125915	11	
128236	1	

MS21043-6 Purchased No 230 Each 106.0000 4 4

MS21043-6

NUT

**

all 15104/20

Location	Loc Qty	Loc Code
FG	20	
103693	20	
FP001	86	
131618	82	
m130325	2	
m130726	2	

D3794-1 Manufactured No 230 Each 18.0000 1 1

D3794-1

Gasket Fwd

**

all 15104/20

Location	Loc Qty	Loc Code
FP001	18	
128238	18	

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Start Date: 3/18/2015

Required Date: 3/18/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

747.0000

8

8

NAS1611-010

O-RING

**

ll 13/04/20

LocationLoc QtyLoc Code

FP001

747

m130770

543

m130797

4

m131618

200

D2741

Manufactured

No

250

Each

40.0000

1

1

D2741

Replacement Blade

**

DAS

27

9-89

MAY 06 2015

DAS

28

9-89

DAS
05
9-89LocationLoc QtyLoc Code

FG

10

100664

3

113640

2

115522

5

ST538

30

128088

30

NAS1515H3L

Purchased

No

230

Each

473.0000

4

4

***NAS1515H3I ***

Washer

**

ll 13/04/20

LocationLoc QtyLoc Code

FG

40

102472

40

FP001

55

m127831

55

ST266

378

m127831

48

m130726

330

x4

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Start Date: 3/18/2015

Required Date: 3/18/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

534.0000

8

8

NAS1611-013

O-RING

**

ll 15/04/20

Location

Loc Qty

Loc Code

FP001

534

m130758

534

AN3C6A

Purchased

No

230

Each

376.0000

4

4

AN3C6A

Bolt

**

ll 15/04/20

Location

Loc Qty

Loc Code

CA

39

m128704

39

FG

10

122416

10

ST338a

327

m128769

327

NAS1149C0832R

Purchased

No

230

Each

138.0000

1

1

NAS1149C0832R

Washer

**

ll 15/04/20

Location

Loc Qty

Loc Code

ST271

138

m125807

138

X1

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Start Date: 3/18/2015

Required Date: 3/18/2015

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

21.0000

1

1

D3536-25

Gasket Center

**

ll 15/04/20

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

15

125909

1

128578

1

130190

13

X 1

D3794-3

Manufactured No

230

Each

56.0000

1

1

D3794-3

Gasket Aft

**

ll 15/04/20

Location

Loc Qty

Loc Code

FP001

56

125917

1

127383

39

128239

15

92658

1

X 1

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Required Date: 3/18/2015

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,293.000

34

34

AN3C5A

Bolt

**

all 15/04/20

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

42

M131420

42

ST338a

826

M130770

10

M130851

16

M131803

800

ST350

420

M131320

420

X34

D3537-1

Manufactured

No

230

Each

96.0000

3

3

D3537-1

Wearpad

**

all 15/04/20

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

38

126306

1

127087

3

128225

3

129514

31

PKG12

40

125911

40

B121358

X3

Picklist Print

Page 8

Wednesday, March 18, 2015 8:46:15 AM

Work Order ID: 130629

130629

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 3/18/2015

Required Date: 3/18/2015

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

48.0000

1

1

D3535-25

Wearplate Center

**

all 12/10/12

LocationLoc QtyLoc Code

FG

2

95077

2

FP002

38

125908

10

128090

3

128224

25

FP007

8

127851

8

X1

D3492-3

Manufactured No

230

Each

101.0000

8

8

D3492-3

Plug

**

all 12/10/12

LocationLoc QtyLoc Code

FP001

101

125905

2

128914

99

13131036

x2

NAS1149C0332R

Purchased No

230

Each

6,644.000

38

38

NAS1149C0332R

WASHER

**

all 12/10/12

LocationLoc QtyLoc Code

FP001

2140

m130325

2140

ST260a

3000

m131697

3000

ST271

1504

m131340

62

m131618

1442

138

Wednesday, March 18, 2015 8:46:15 AM

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Page 9

Wednesday, March 18, 2015 8:46:15 AM

Work Order ID: 130629

130629

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 3/18/2015

Required Date: 3/18/2015

Start Qty: 1.00

Required Qty: 1.00

D3488-042 Manufactured No

230 Each

10.0000

1

1

D3488-042

Blade Fitting RH

**

ll 15/04/20

LocationLoc QtyLoc Code

FP001

10

128804

10

x1

ALS4-1032-225 AELS8-1032-225 Purchased No

230 Each

2,081.000

38

38

ALS4-1032-225

Rivnut

**

ll 15/04/20

LocationLoc QtyLoc Code

FG

120

M127028

120

FP001

19

M131067

19

st549

1942

M131582

1942

x 38

D3492-1 Manufactured No

230 Each

133.0000

8

8

D3492-1

Plug

**

ll 15/04/20

LocationLoc QtyLoc Code

FP001

133

128509

16

128955

117

B131113

x3

x5

D3793-1 Manufactured No

230 Each

14.0000

1

1

D3793-1

Wearplate Fwd

**

ll 15/04/20

LocationLoc QtyLoc Code

FP002

14

125914

13

128235

1

x1

Wednesday, March 18, 2015 8:46:15 AM

Shop Packet Print

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Picklist Print

Page 10

Wednesday, March 18, 2015 8:46:15 AM

Work Order ID: 130629

130629

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 3/18/2015

Required Date: 3/18/2015

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

7.0000

1

1

AN8C35A

Bolt

**

all 1310420

Location

Loc Qty

Loc Code

FG

5

121275

5

M131947

xl

FP001

2

131651

2

MS21083C8

Purchased

No

230

Each

78.0000

1

1

MS21083C8

Nut

**

all 1310420

Location

Loc Qty

Loc Code

ST299

60

m131618

60

ST300

18

m131049

18

D2745

Manufactured

No

230

Each

191.0000

8

8

D2745

Bushing

**

all 1310420

Location

Loc Qty

Loc Code

FP001

183

128089

63

129584

120

ST010

8

128480

8

xe

Picklist Print

Page 11

Wednesday, March 18, 2015 8:46:15 AM

Work Order ID: 130629

130629

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 3/18/2015

Required Date: 3/18/2015

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

234.0000

4

4

AN6C44A

Bolt

**

all 15/04/20

Location

Loc Qty

Loc Code

FG

2

103964

2

11131856

44

FP001

5

m130863

4

m131367

1

ST286A

162

131649

100

131651

49

m130863

13

ST332

11

m130863

11

ST333

54

m131151

50

m131546

4

D3532-1

Manufactured

No

250

Each

2.0000

2

2

D3532-1

Spacer

*DAS
06
9-89*

**

Location

Loc Qty

Loc Code

ST048

2

128091

2

B128964

2

*DAS
27
9-89*

*DAS
28
9-89*

MS21083C8

Purchased

No

250

Each

78.0000

2

2

MS21083C8

Nut

*DAS
06
9-89*

**

Location

Loc Qty

Loc Code

ST299

60

m131618

60

ST300

18

m131049

18

2

APR 28 2015

*DAS
27
9-89*

*DAS
28
9-89*

Wednesday, March 18, 2015 8:46:16 AM

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Page 11

Picklist Print

Page 12

Wednesday, March 18, 2015 8:46:16 AM

Work Order ID: 130629

130629

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 3/18/2015

Required Date: 3/18/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

676.0000

2

2

NAS1149D0863.I

Washer

**

DAS

27

9-89

DAS
CS
9-89

Location

Loc Qty

Loc Code

FP001

57

125484

57

ST260a

421

125268

321

125635

100

ST269

198

125268

198

D3493-1

Manufactured

No

250

Each

102.0000

2

2

D3493-1

Washer

**

DAS

27

9-89

DAS
CS
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

92

125906

1

128755

91

APR 28 2015

DAS
28
9-89

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

AN8C21A

Purchased

No

250

Each

15.0000

2

2

AN8C21A

Bolt

**

DAS

27

9-89

DAS
CS
9-89

Location

Loc Qty

Loc Code

FG

2

123966

2

ST312A

11

131651

11

ST332

2

m131100

2

131947

DAS
28
9-89

Wednesday, March 18, 2015 8:46:16 AM

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

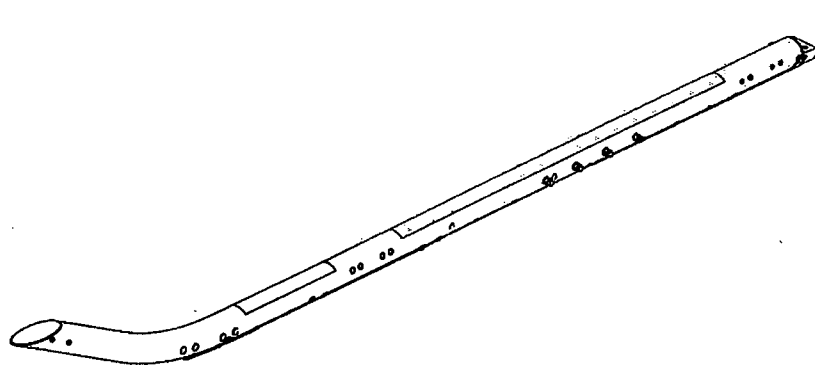
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL "F" SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
 FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

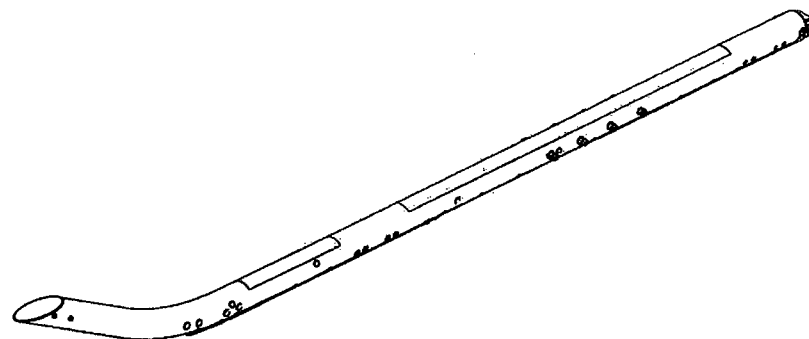
130629 MCT
1503-18

RELEASED
2013-08-13
ND

G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3532-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/DAFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 05-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2750 TITLE 350 SKIDTUBE ASSEMBLY COPYRIGHT © 1996 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION OF THIS DOCUMENT IS PERMITTED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DRAWN	JS		
CHECKED	JS		
MFG. APPR.	JS		
APPROVED	JS		
DE APPR.	JS	REV. G SHEET 1 OF 11 SCALE NTS	
DATE	13.07.11		



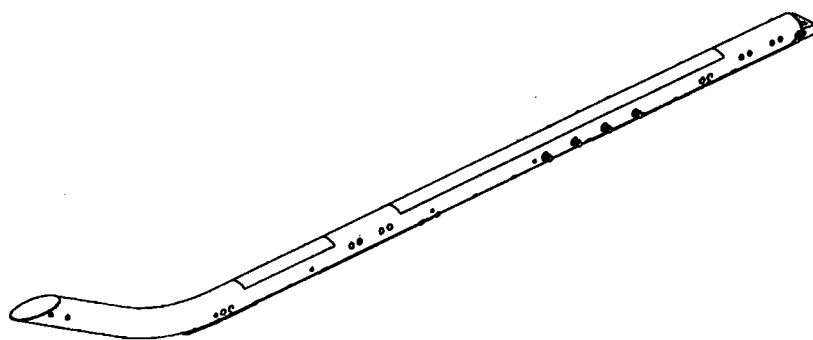
D2750-041 350 SKIDTUBE ASSEMBLY, LH



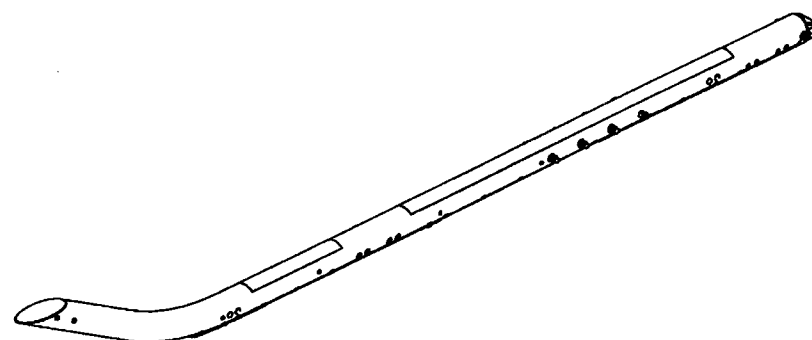
D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
MP

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DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



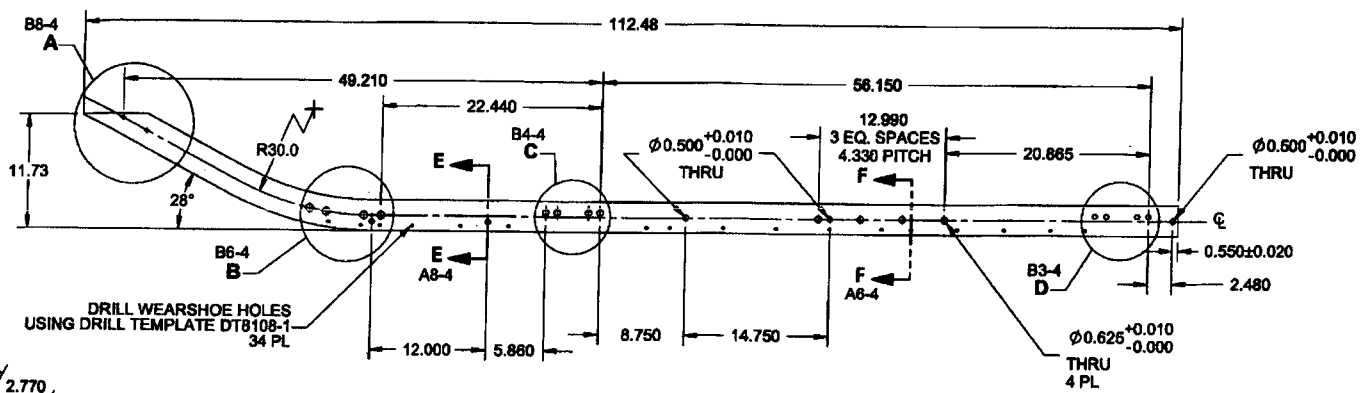
D2750-043 350 SKIDTUBE ASSEMBLY, LH



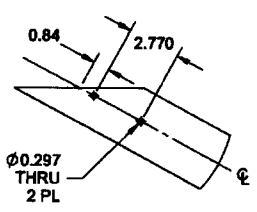
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
SW

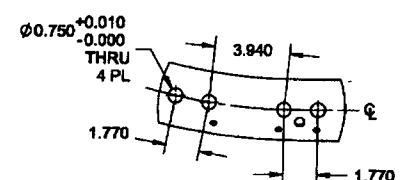
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CHECKED	<i>[Signature]</i>	DRAWING NO. D2750	REV. G
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 11	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



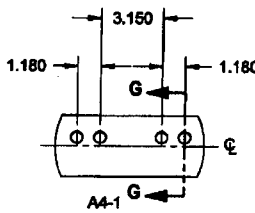
D2750-1 LH SKIDTUBE



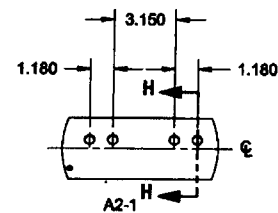
DETAIL A
SCALE 2X



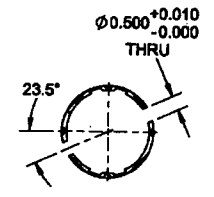
DETAIL B
SCALE 2X



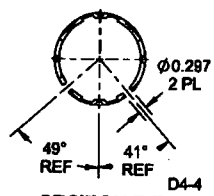
DETAIL C
SCALE 2X



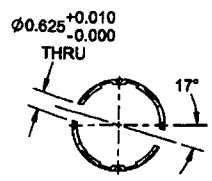
DETAIL D
SCALE 2X



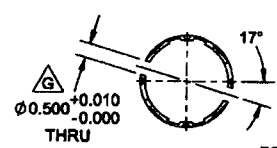
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

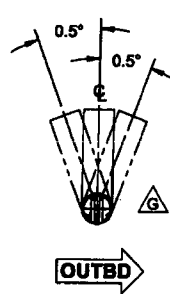
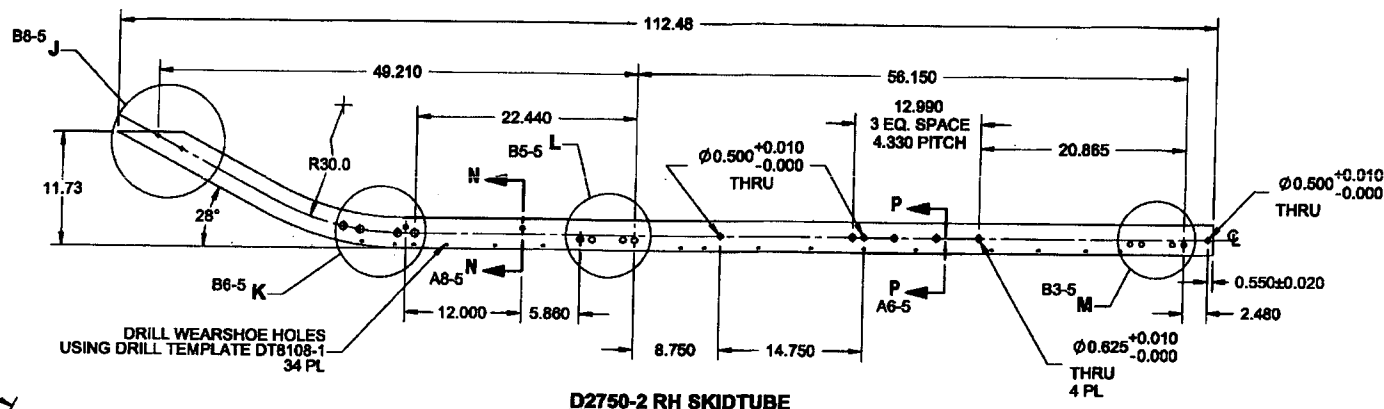


SECTION H-H
SCALE 3X, 4 PL

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DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	13.07.11

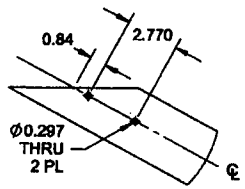
DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D2750	REV. G SHEET 4 OF 11
TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

RELEASED
2013-08-13

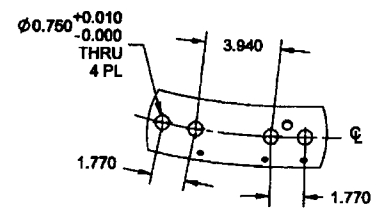


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

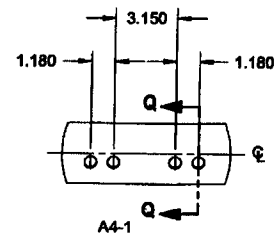
D2750-2 RH SKIDTUBE



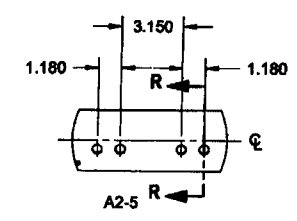
DETAIL J
SCALE 2X



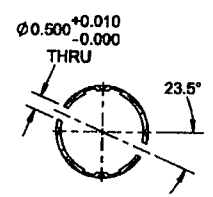
DETAIL K
SCALE 2X



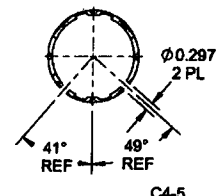
DETAIL L
SCALE 2X



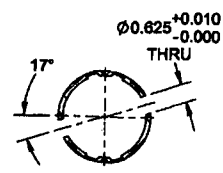
DETAIL M
SCALE 2X



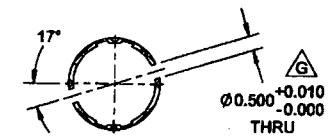
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

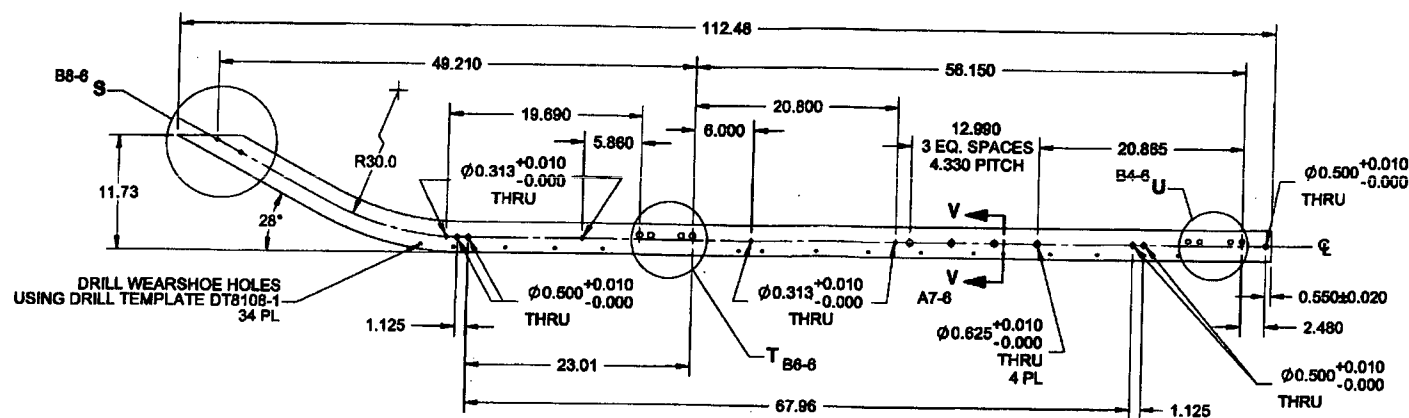


SECTION R-R
SCALE 3X, 4 PL

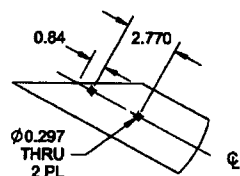
RELEASED
2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 5 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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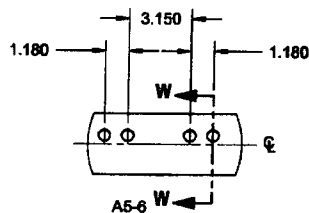
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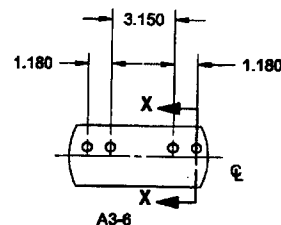
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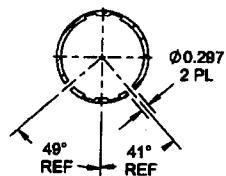
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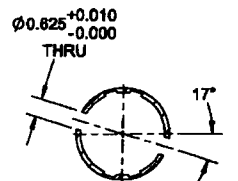
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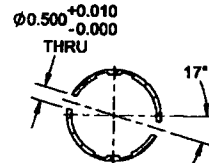
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SECTION V-V
SCALE 3X, 17 PL



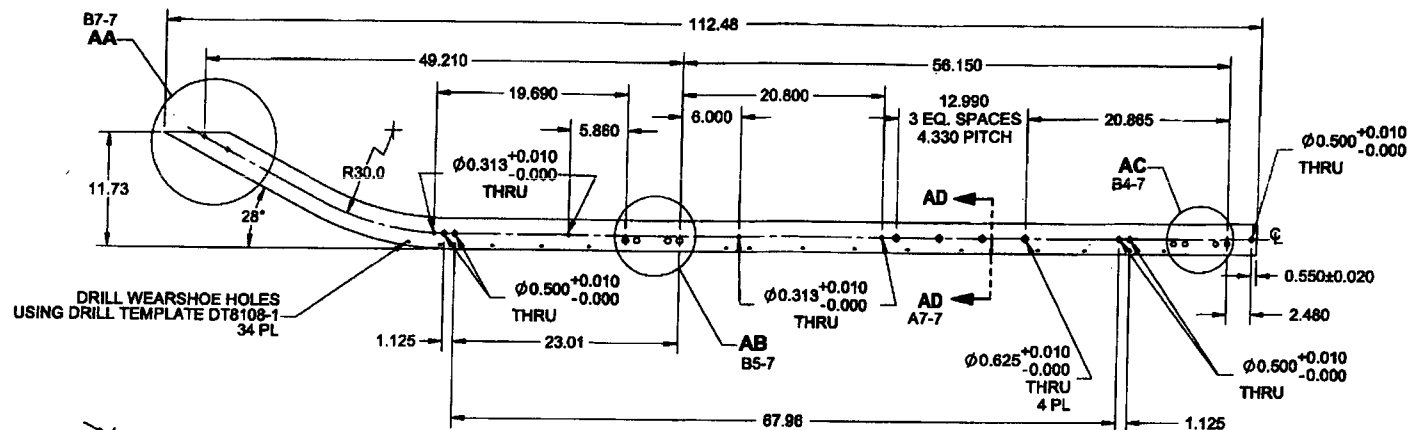
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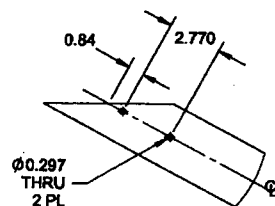
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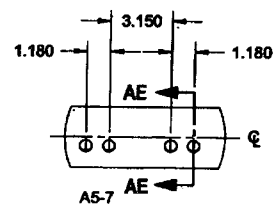
DESIGN	MM	DART AEROSPACE USA, INC.	
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MFG. APPR.		D2750	SHEET 6 OF 11
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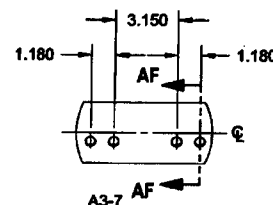
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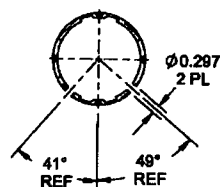
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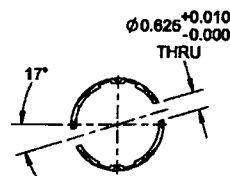
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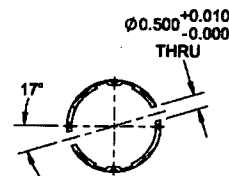
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SECTION AD-AD
D3-7
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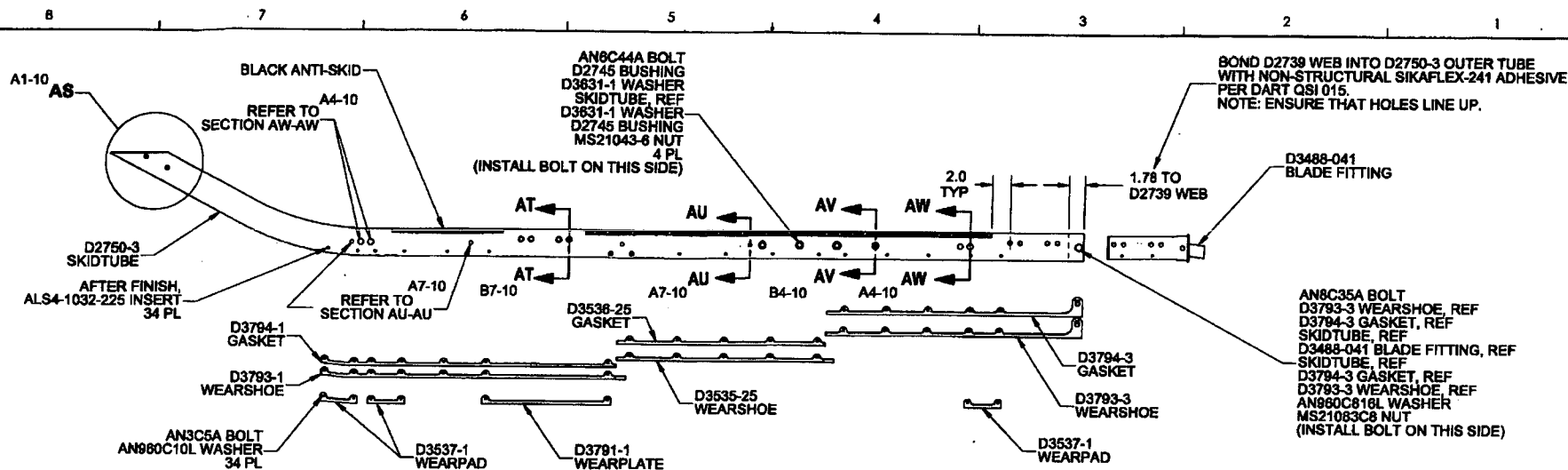
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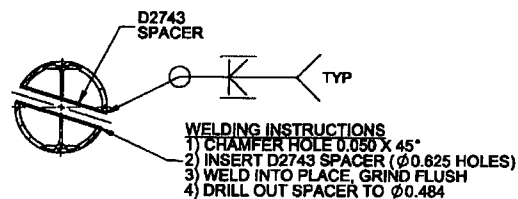
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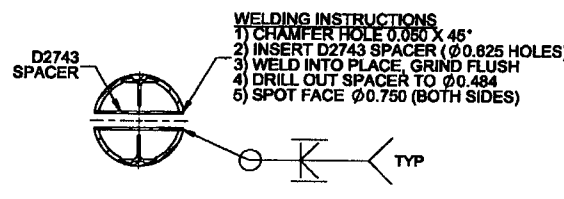


D2750-043 350 SKIDTUBE ASSEMBLY, LH

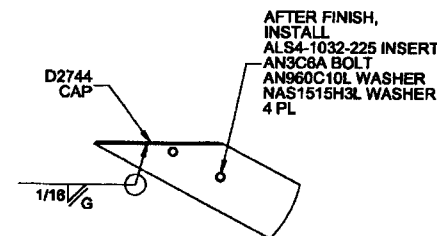
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2013-08-13



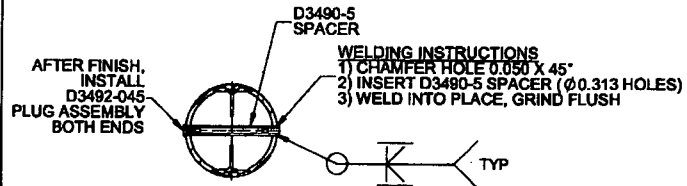
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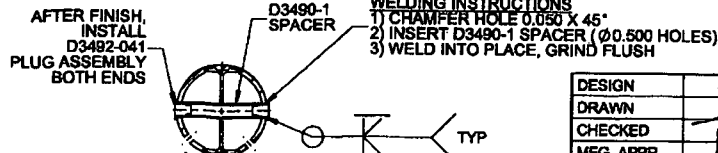
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DETAIL AS
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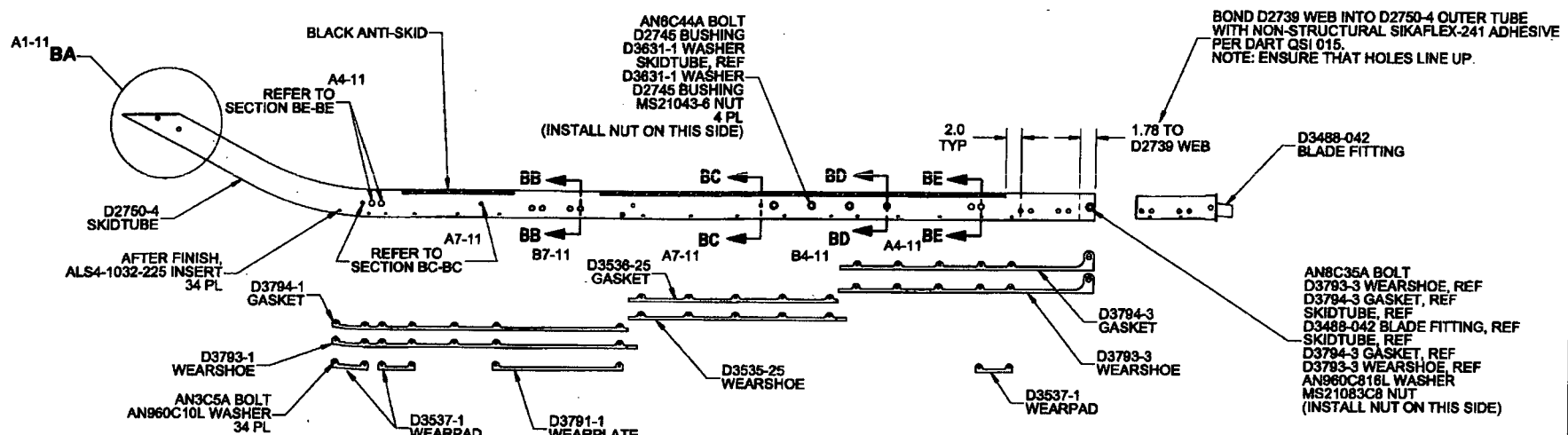
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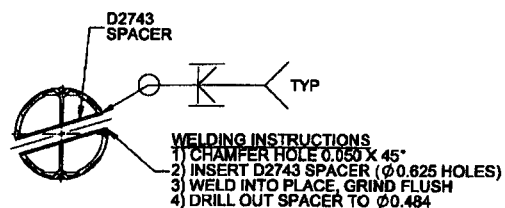
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8 7 6 5 4 3 2 1



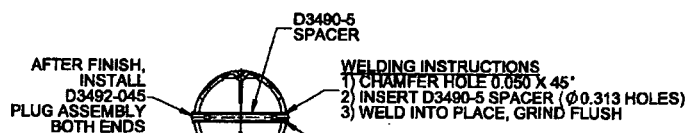
D2750-044 350 SKIDTUBE ASSEMBLY, RH



SECTION BB-BB
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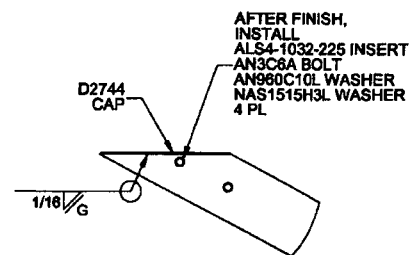
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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